



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4577-041
Job Sheet 180694



Part No: D4577-041

Job Qty: ¹² 5 ea

Part Name: Fwd Access Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,4 IPP REV:A 12.03.08 NEW ISSUE DD VERF:EC IPP REV:B 12.04.25 AS PER
DWG REV.B DD VERF:EC IPP REV:C 15.01.15 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	5 Ea	7/31/18		0.00	0.00	Start Up Waterjet		dc 18/07/18
100	Waterjet	5 pcs	7/31/18		0.00	0.86	Waterjet1		dc 18/07/18
110	QC	5 pcs	7/31/18		0.00	0.00	QC2		dc 18/07/18
120	QC	5 pcs	7/31/18		0.00	0.00	QC8		38
130	Small Fab	5 pcs	7/31/18		0.00	0.60	Small Fab		38
140	QC	5 pcs	7/31/18		0.00	0.00	QC5		38
150	HandFinish	5 pcs	7/31/18		0.00	0.45	HandFinish1		SA 18-07-25
160	QC	5 pcs	7/31/18		0.00	0.00	QC7		38
170	Small Fab	5 pcs	7/31/18		0.00	0.60	Small Fab		38
180	QC	5 pcs	7/31/18		0.00	0.00	QC5		38
220	Packaging	5 pcs	7/31/18		0.00	0.00	Packaging3		38
230	QC21-SA	5 Ea	7/31/18		0.00	0.00	QC21		38

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	3.8350 sf (.767 ea)	90-Start up Operation	50180059
MS20426AD3-5	Rivet	50 Ea (10 ea)	170-Small Fab	F4533
NAS1474R3	Anchor Nut	25 Ea (5 ea)	170-Small Fab	F413686C 10x 5038791 10x
				5095435 5x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.125	4	85	0
170-Small Fab	MS20426AD3-5	50	7,982	0
	NAS1474R3	25	20	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description W _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rep/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																							
		MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																							
Dart Aerospace Ltd. 1270 Aberdeen Street Hockleybury, ON K64 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/17/19		Container No: S092559 Part: D4577 - 041 Job No: 180694 Serial No/Batch: S092559 Revision: Inspector: Exp Date: Instructions:																																																																																							
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%; border-collapse: collapse;"> <tr><td>☐ Center Not Concentric</td><td>☐ BOM/Route</td><td>☐ Grain</td><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Cracks</td><td>☐ Broken/Damage/Defect</td><td>☐ Weld</td><td>☐ Outside Dimensions</td></tr> <tr><td>☐ Crimp/Kink/Ripple/Wave</td><td>☐ Inspection Incomplete/Unqualified</td><td>☐ Wrong Stock Pulled</td><td>☐ Over/Under tolerance</td></tr> <tr><td>☐ Cuffs</td><td>☐ Contamination</td><td>☐ Out of Sequence</td><td>☐ Part Incorrect</td></tr> <tr><td>☐ Crushing</td><td>☐ Countersink</td><td>☐ Off-set</td><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Heat Treat</td><td>☐ Cut Too Short</td><td>☐ Mislabeled</td><td>☐ Part Moved</td></tr> <tr><td>☐ Wave/Twist in Tube</td><td>☐ Instructions Incomplete/Unclear</td><td>☐ Fit/Function</td><td>☐ Drawing</td></tr> <tr><td>☐ Marks/Chatter</td><td>☐ Drill Holes</td><td>☐ Misaligned/off center</td><td>☐ Finish</td></tr> <tr><td colspan="2" style="text-align: center;">OTHER :</td><td colspan="2">☐ Turning Sequence</td></tr> </table>				☐ Center Not Concentric	☐ BOM/Route	☐ Grain	☐ Positioned Wrong	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Outside Dimensions	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Over/Under tolerance	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Incorrect	☐ Crushing	☐ Countersink	☐ Off-set	☐ Part Lost/Missing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Part Moved	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Drawing	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Finish	OTHER :		☐ Turning Sequence	
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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
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